

**Work Order ID 63250**

Page 1

Tuesday, October 26, 2010 2:31:50 PM

Item ID: D212-725-1-095

Accept



Setup Start



Revision ID:

Item Name: Radius Block

Stop



Start Date: 10/26/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10/10/26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D212-725-1

Rev B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev:

Prog Rev:

6061 .125

2-Deburr if necessary

PB 10-10-27

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

PB 10-10-27

**Work Order ID 63250**

Tuesday, October 26, 2010 2:31:50 PM

Page 2

Item ID: D212-725-1-095

Accept

Setup Start

Revision ID:

Stop

Item Name: Radius Block

Start Date: 10/26/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

8/10/10/27



QC

Memo

0.00

Quality Control

(X4)

130

Memo

0.00



Small Fab

1- Grind a 45 degree chamfer as per dwg.

0.00

⇒ ml w/w/28

Small Fab

(4X)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/10/28

(X4)

# Work Order ID 63250

Tuesday, October 26, 2010 2:31:50 PM



Page 3

Item ID: D212-725-1-095

Accept



Setup Start



Revision ID:

Item Name: Radius Block

Stop



Start Date: 10/26/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing	***FLAT PATTERN ONLY***								
160 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
170 	Identify as per dwg & Stock Location: 384	0.00							
Packaging	Memo	0.00							
Packaging									

Handwritten: 4 BR 10-10-28.

Handwritten: => M 10/10/26

Handwritten: 4 0

Handwritten: 10/14/28 (4)

**Work Order ID 63250**

Tuesday, October 26, 2010 2:31:50 PM



Page 4

Item ID: D212-725-1-095

Accept



Setup Start



Revision ID:

Item Name: Radius Block

Stop



Start Date: 10/26/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/29 JF  
MF  
10-10-28

# Picklist Print

Tuesday, October 26, 2010 2:31:54 PM

Page 1

Work Order ID: 63250

Parent Item: D212-725-1-095

Parent Item Name: Radius Block



Start Date: 10/26/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.10.26 as per dwg rev.G DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	91.4600	0.0067	0.028211			



6061-T6 .125 Sheet



KB 10-10-07

Location

Loc Qty

Loc Code

MAT21

91.46

113608

91.46

113608

⑤

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

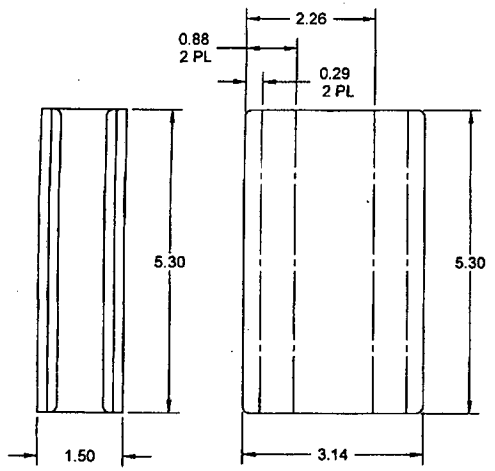
DDA-725-1-095

☒ **First Article**     ☐ **Prototype**

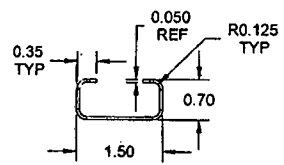
Measured by:	JB	Audited by:	S	Prototype Approval:	N/A
Date:	10-10-27	Date:	10/10/27	Date:	N/A

H:\FORMS\Quality Assurance\approved QA\FAI revD

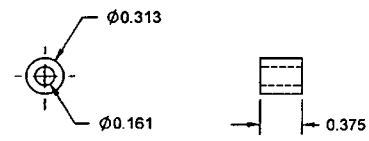
8 7 6 5 4 3 2 1



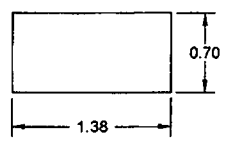
**D212-725-1-081F FLAT PATTERN**



**D212-725-1-081 SUPPORT**  
(MAKE FROM D212-725-1-081F FLAT PATTERN)



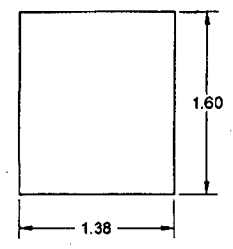
**D212-725-1-101 SPACER**



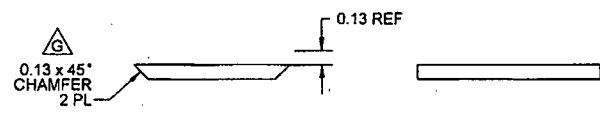
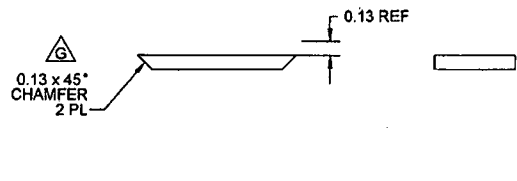
**D212-725-1-095 RADIUS BLOCK**



**D212-725-1-097 PACKER**



**D212-725-1-099 RADIUS BLOCK**



- D212-725-1-095/-097/-099 NOTES:**  
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221  
REF DART SPEC. M6061T6B  
OR 6061-T6/T62 ALUMINUM SHEET  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC. M6061T6S  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- D212-725-1-101 NOTES:**  
1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM ROUND BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC. M6061T6R  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

- D212-725-1-081 NOTES:**  
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED, 2B FINISH 0.050 (18 GAUGE) THICK  
PER AMS-5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240  
REF DART SPEC. M304S18GA  
2) FINISH: NONE
- GENERAL NOTES:**  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 63250

RELEASED  
10.03.71

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	140	DRAWING NO.	REV. G
MFG. APPR.	140	D212-725-1	SHEET 31 OF 84
APPROVED	140	TITLE	SCALE
DE APPR.	140	212S DETAIL PARTS	NTS
DATE	10.02.12	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries